

Date: Wednesday, 29/04/2009 3:02:02 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BEARING
Job Number : 47606	
Estimate Number : 10091	
P.O. Number :	Part Number : D31835
This Issue : 29/04/2009 S.O. No. :	Drawing Number : D3183 REV. C1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : C1
Previous Run : 46853	Material : 304/05
Written By :	Due Date : 30/04/2009
Checked & Approved By : <u>JLD 09.04.29</u>	Qty : 40 Um: Each
Comment : Est: A 03.03.27 New issue KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASINGIssue P/O: 8706CL09/04/30

Bearing as per Dwg D3183

Single row, deep groove, Conrad type, shielded

Possible Supplier: NSK P/N 6800ZZ

Certificate of conformity note is required

(40)

2.0	6800ZZ	Bearing
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

BEARING

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

P 9/5/4 (40)

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK509/05/05 (40) counter

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: 9369/5/5(40) SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 29/04/2009 3:02:02 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING

Job Number: 47606

Part Number: D31835

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/05 [Signature]

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf
09-05-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector






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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

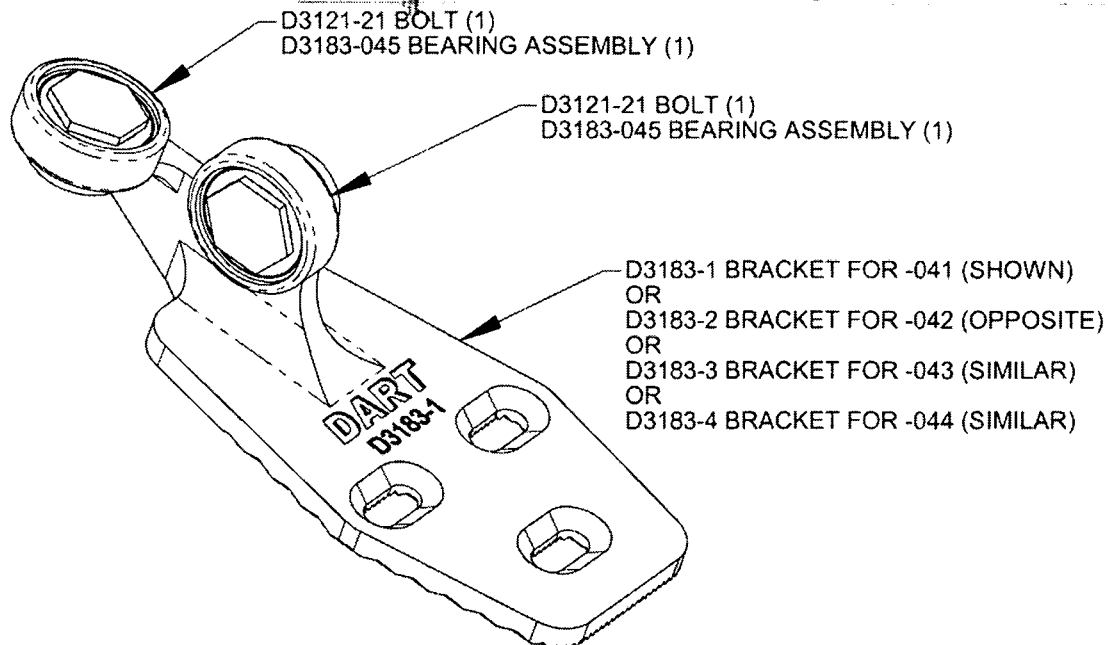
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

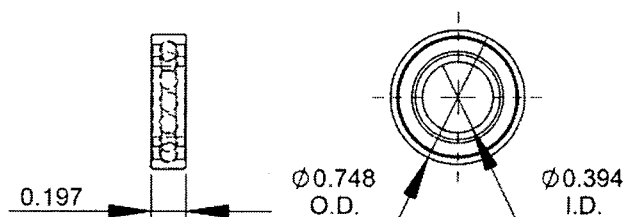


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CHECKED 		APPROVED 		DRAWING NO. D3183	REV. C SHEET 1 OF 4
DATE 04.02.17			TITLE BRACKET ASSEMBLY SCALE 1:1		
A	03.01.24		NEW ISSUE		
B	03.06.17		REMOVE BEARING; 1.012 WS 0.882		
C	04.02.17		ADD -045/-9; 0.182 WAS 0.431		
C1	 04.11.07, 0.830 WAS 0.850				

RELEASED
04 03 01

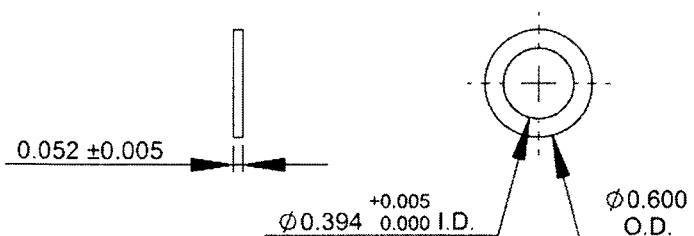


D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



D3183-5 BEARING:
SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES



D3183-7 WASHER

- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER

NO. 47600

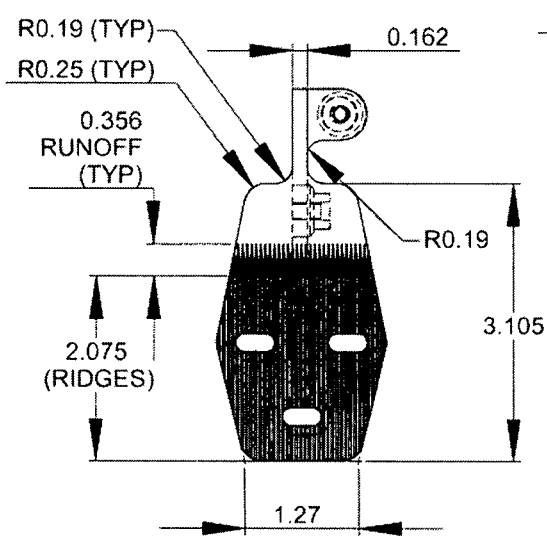
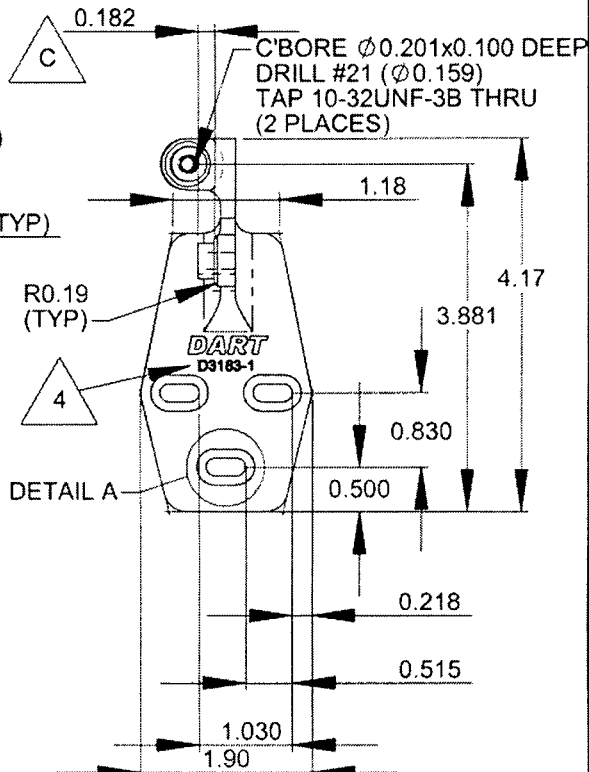
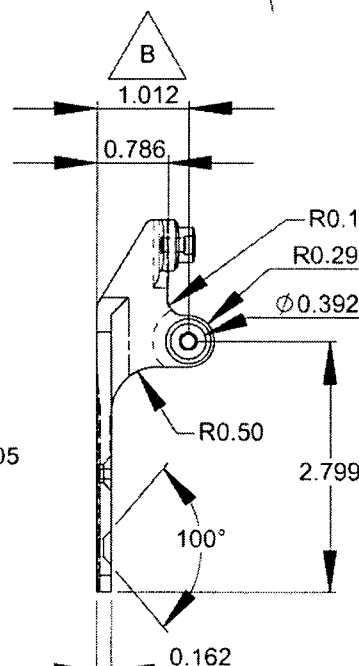
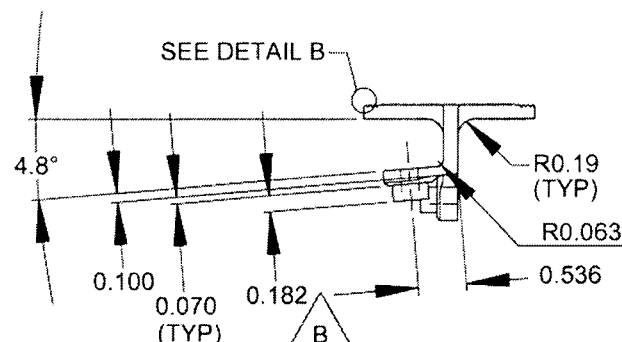
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04.02.17	D3183	SHEET 2 OF 4
	BRACKET ASSEMBLY	SCALE 1:2



**D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE**

- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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LA COM 1-15-52

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DATE		D3183	SHEET 3 OF 4
04.02.17		TITLE	SCALE
		BRACKET ASSEMBLY	1:2



1) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi

2) BREAK ALL SHARP EDGES 0.005 TO 0.015

3) ENGRAVE DART P/N & LOGO AS SHOWN

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

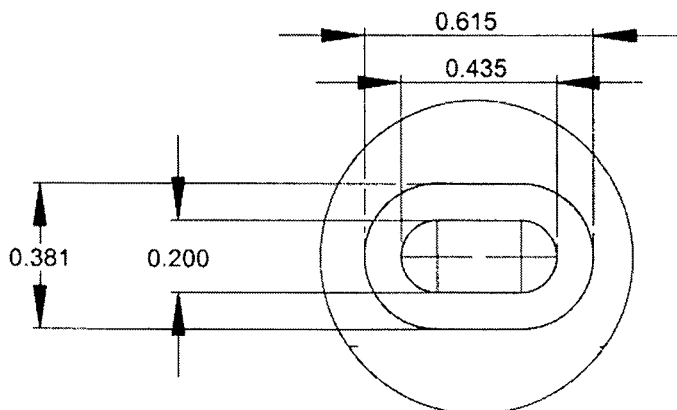
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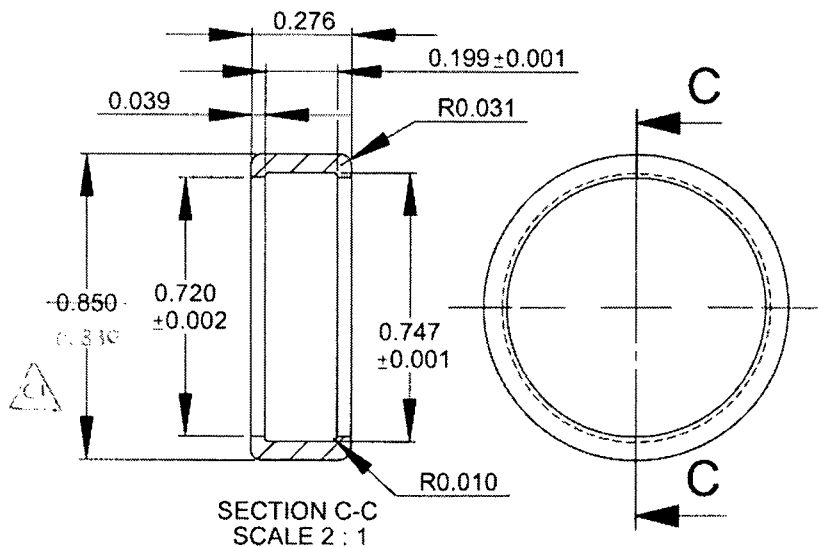
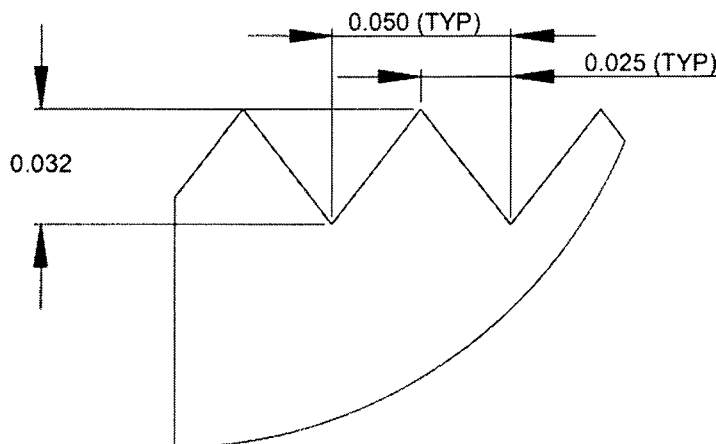
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3183	REV. C SHEET 4 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1



RELEASED
04.03.01



D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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GENERAL BEARING SERVICE

INC.

WWW.GBS.CO

225 MAIN ST. E. WAKESBURY, ONTARIO K6A 1B8 (613) 632-9914

ORDER DATE: MAY 1, 2009

PST LICENCE: 6122-5207

PRICE EXTENSION

195.60
4.89
9.78

G.S.T.

K6A-1K7

BOLD TO: DART AEROSPACE LTD.
1870 ROBERTSON STREET
WAKESBURY, ONT.

GBS 613-619197994

GENERAL BEARING SERVICE INC.

SALE MADE BY: JF
SHIP VIA:

CUSTOMER ORDER #: 0000706

10-E 8 CM 10-T10-N

BALL BEARING

6000-77

05/01/09

RECEIVED

THIS FORM MUST BE COMPLETED BY THE CUSTOMER AND RETURNED TO THE SUPPLIER WITH THE INVOICE.
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